

Date: Friday, 01/08/2008 3:32:19 PM  
 User: Julie Lecocq

## Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	: END FITTING ASS'Y		
Job Number	40969			Part Number	: D3763045		
Estimate Number	13475			Drawing Number	: D3763 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	: 01/08/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 21/08/2008	Qty:	2 Um: Each
Previous Run	40968						
Written By	:						
Checked & Approved By	: JUL 08 . 8.05						
Comment	: Est Rev:A 08-07-18 new issue DD verified by:ec						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description.:	
1.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Pick Packing Kit	
2.0	D37631	End Fitting	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) End Fitting batch: 40703	SP
3.0	D37637	Tube	
			(2x)
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s) Tube batch: 40707	SP
4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1 1-make a 0.063" chamfer on D3763-1 fitting before ass'y 2-assemble and tack weld as per dwg D3763 using locating pin DT9014 DT9039 SP 08.08.14 ***remove pin before welding****	SP 08.08.14
		3-weld as per dwg D3763 , QSI004 Alum. rod Batch: M108037	SP 08.08.14 (2x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: END FITTING ASS'Y

Job Number: 40969

Part Number: D3763045

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC9

VISUAL WELDING INSPECTION



08/08/14



(x2)

Comment: VISUAL WELDING INSPECTION

6.0 QC5

INSPECT WORK TO CURRENT STEP



08/08/14 (2)



(P/C)

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock Location: GA

MF 08-08-14

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

Do 08/08/15

Job Completion



MF 08-08-14

6.2 - Chemical conversion coat

6.3 QC3. MF 08/08/14 (2X)

W/O: 40969		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3763-045 PAR #: N/A Fault Category: Prod. Eng. Co-ord. NCR: Yes No DQA: D Date: 08/08/15  
 QA: N/C Closed: D Date: 08/08/15

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/08/14	6.0	Chemical conversion count step is not an estimate. Estimates were verified.	/lesicelz	Add to Estimate in QC 3		/lesicelz	/lesicelz	/lesicelz

NOTE: Date & initial all entries

